

Work Order ID 74885

October-13-11 10:45:41 AM

74885

Page 1

Item ID: D2281

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Jack Saddle

Start Date: 10/13/11 Start Qty: 150.00

150

Cust Item ID:

Required Date: 11/15/11 Req'd Qty: 150.00

150

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2281

Rev G

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281 Dwg Rev: G Prog Rev: G 2-Deburr if necessary B11-10-08

B11-10-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B11-10-13

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

M 11/10/31

Work Order ID 74885

October-13-11 10:45:41 AM

74885

Page 2

Item ID: D2281

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Jack Saddle

Start Date: 10/13/11 Start Qty: 150.00

150

Cust Item ID:

Required Date: 11/15/11 Req'd Qty: 150.00

150

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

Debur

0.00

0.00

140

140

Brake NC

Brake NC

NC BRAKE

Memo

Form as per D2281 using D2281-T2

0.00

0.00

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Work Order ID 74885

October-13-11 10:45:41 AM

74885

Page 3

Item ID: D2281

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Jack Saddle

Start Date: 10/13/11 Start Qty: 150.00

150

Cust Item ID:

Required Date: 11/15/11 Req'd Qty: 150.00

150

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

Identify as per dwg & Stock Location: WA

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

11/11/11 SP

136

11/11/01
ME 11-11-01

Picklist Print

October-13-11 10:45:41 AM

Page 1

Work Order ID: 74885

Parent Item: D2281

Parent Item Name: Jack Saddle

Start Date: 10/13/11

Required Date: 11/15/11

Start Qty: 150.00

Required Qty: 150.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 304SS sheet .080		Purchased	No			100	sf	44.1000	0.125	19.736842			

Location

Loc Qty

Loc Code

MAT020

44.1

113295

12.1

117933

32

113295

1811-10-13

DART AEROSPACE LTD		Work Order:	74885
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.476	2		V BOL	
4.114	+/-0.010	4.114	2		V	
2.933	+/-0.010	2.936	2		V	
1.535	+/-0.010	1.540	2		V	
0.354	+/-0.010	0.355	2		V	
0.354	+/-0.010	0.354	2		V	
0.604	+/-0.010	0.604	X		V	
2.000	+/-0.010	1.999	2		V	
3.396	+/-0.010	3.396	2		V	
3.646	+/-0.010	3.646	X		V	
4.000	+/-0.010	4.009	2		V	
1.525	+/-0.010	1.533	2		V	
2.475	+/-0.010	2.479	2		V	
Ø0.323	+0.006/-0.001	-0.323	2		V	
0.080	+/-0.010	0.075	2		V	

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-10-13	Date: 11/10/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

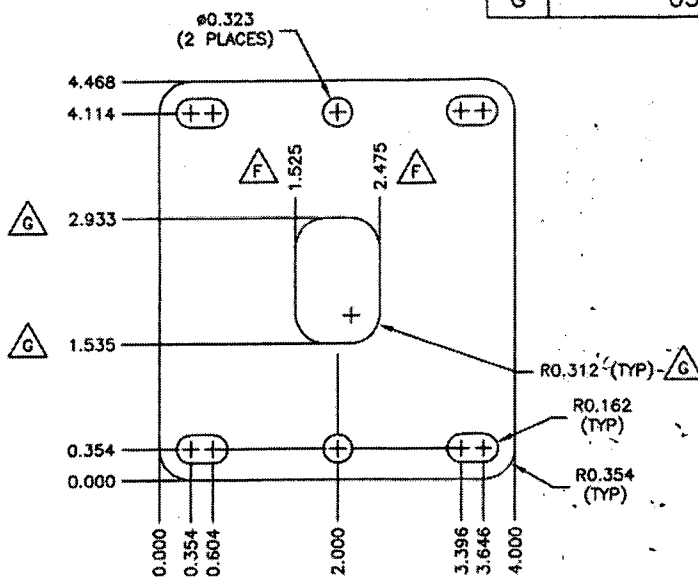
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

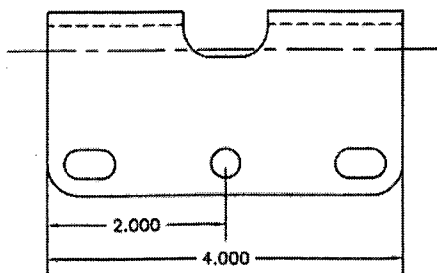


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE		SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11

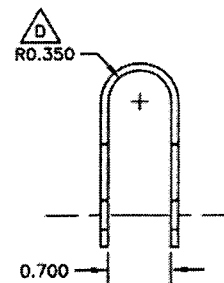


FLAT LAYOUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74885 M.L.J

11/10/11



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries